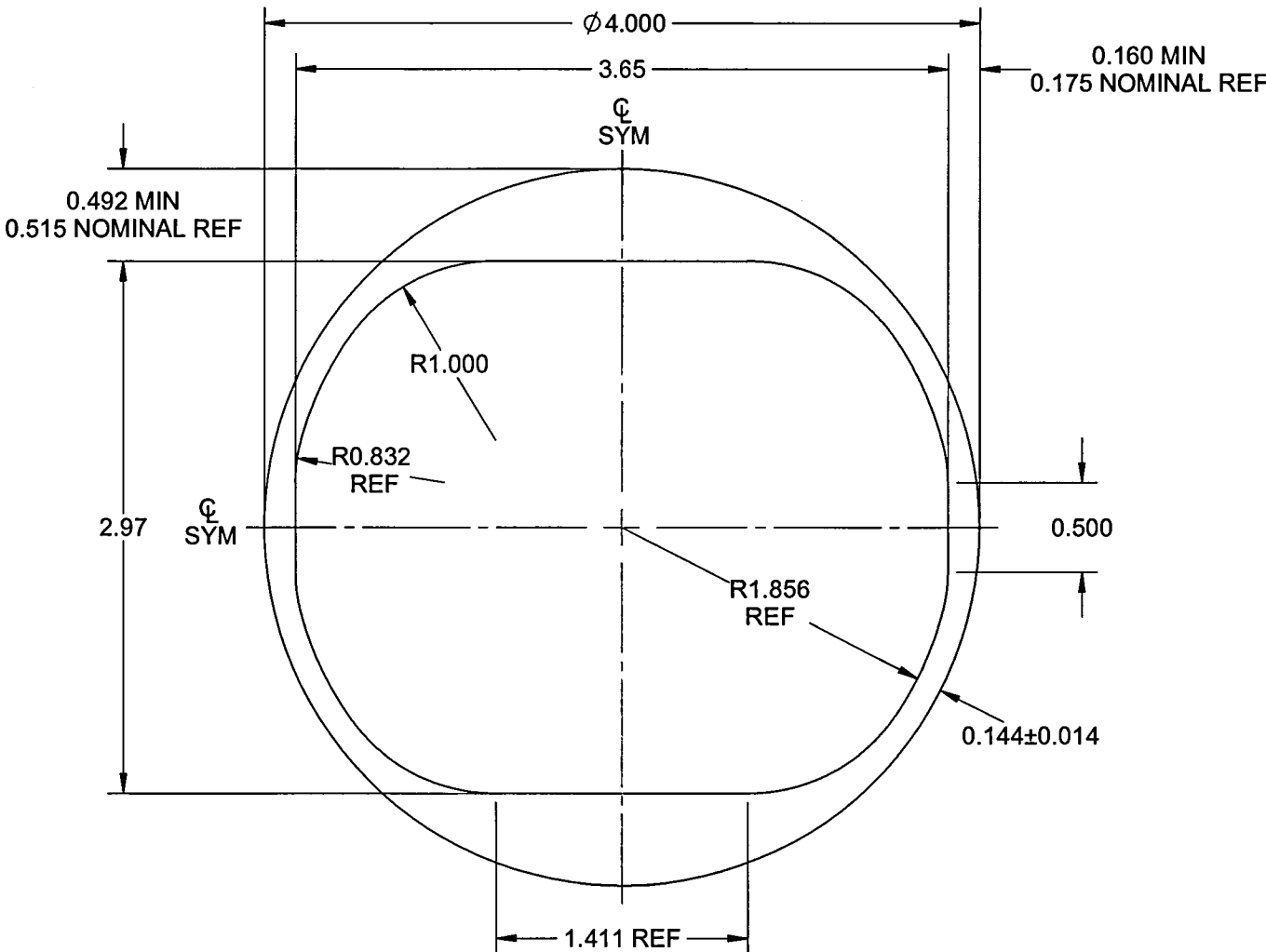


SPECIFICATION CONTROL DRAWING



D6028-XXX TUBE, SEAMLESS

WHERE XXX IS LENGTH IN INCHES
EG. 195" LONG TUBE: D6028-195

NOTES:

- 1) MATERIAL: 4.000" OD 7075-T73/T73511 SEAMLESS ALUMINUM TUBE
PER (QQ-A-200/11 OR OR AMS 4617 OR AMS 4167 OR AMS 4166 OR ASTM B241)
MINIMUM ULTIMATE TENSILE STRENGTH = 68 KSI
MINIMUM YIELD TENSILE STRENGTH = 58 KSI
- 2) FINISH: NONE
- 3) TOLERANCES: O.D.: +/- 0.016" MEAN (+/- 0.024" INCLUDING OVALITY)
LENGTH: XXX +0.5"/-0.000"
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
TWIST: 0.25 ° DEVIATION / 12" LENGTH, 3 ° MAXIMUM OVER TOTAL LENGTH
OTHER DIMENSIONS PER DART QSI 018 EXCEPT AS NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.307 LB/IN
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH
AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) MANUFACTURE PER ALUNNA DIE# XA12253

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DE APPR.	DS	TUBE, SEAMLESS	NTS
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